

Work Order ID 90296

90296

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September-17-12 8:52:00 AM

Item ID: D3065-041 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Step Leg Assembly Hi
 Start Date: 9/17/12 Start Qty: 20.00 *20* Cust Item ID:
 Required Date: 10/12/12 Req'd Qty: 20.00 *20* Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 12-09-17 Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3065	Rev B								
100		0.00							
100	Small Fab								
Small Fab	Memo	0.00							
Small Fab	Assemble as per Dwg D3065 and Identify as D3065-041								
110		0.00							
110	QC5- Inspect part completeness to step on W/O								
QC	Memo	0.00							
Quality Control									
120		0.00							
120	Identify as per dwg & Stock Location: <u>W14</u>								
Packaging	Memo	0.00							
Packaging									

20x 12/11/17

20 12/11/22 23 89 DA SB

20 12/11/22

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Item ID: D3065-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Step Leg Assembly Hi

Start Date: 9/17/12 Start Qty: 20.00

20

Cust Item ID:

Required Date: 10/12/12 Req'd Qty: 20.00

20

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC21- Final Inspection - Work Order Release	0.00							
130									
QC	Memo	0.00							
Quality Control									

12/11/22 *[Signature]*
ME
12-11-22

Picklist Print

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12

Work Order ID: 90296

Parent Item: D3065-041

Parent Item Name: Step Leg Assembly Hi

Start Date: 9/17/12

Required Date: 10/12/12

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP Rev: C02.11.01 Incorporated D3066-1 IPPKJ/RF

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3065-1 Step Spacer		Manufactured	No			100	Each	71.0000	1	20		12/11/15	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				GA		71							
				74497		1							
				81303		1							
				83733		30							
				85469		39							
D3065-3 Step Spacer		Manufactured	No			100	Each	72.0000	1	20		12/11/15	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				GA		72							
				69827		1							
				73290		4							
				75152		14							
				83734		12							
				83873		1							
				85470		40							
D3065-5 Step Leg		Manufactured	No			100	Each	200.0000	2	40		12/11/15	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				GA		200							
				67222		1							
				73289		19							
				85462		60							
				88827		80							
				89239		40							

B88825 (192)
B90766 (1K)

B89939 (3K)
B89938 (17K)

B90073
(40K)

Picklist Print

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Work Order ID: 90296

Parent Item: D3065-041

Parent Item Name: Step Leg Assembly Hi

Start Date: 9/17/12

Required Date: 10/12/12

Start Qty: 20.00

Required Qty: 20.00

D3065-7
Step Spacer

Manufactured No

100 Each 61.0000 1 20

Location

Loc Qty

Loc Code

GA	61
73291	7
74499	1
78666	4
83738	1
83875	9
85471	39

B 90705 (124)
B 90520 (82)

MS20470AD4-4
Rivet, Universal Head

Purchased No

100 Each 7.607.0000 30 600

Location

Loc Qty

Loc Code

ST313	2662
122027	2600
122063	62
ST319	4945
116188	136
116391	66
118614	912
119109	26
121011	5
121556	800
121652	3000

M123352
(6000)

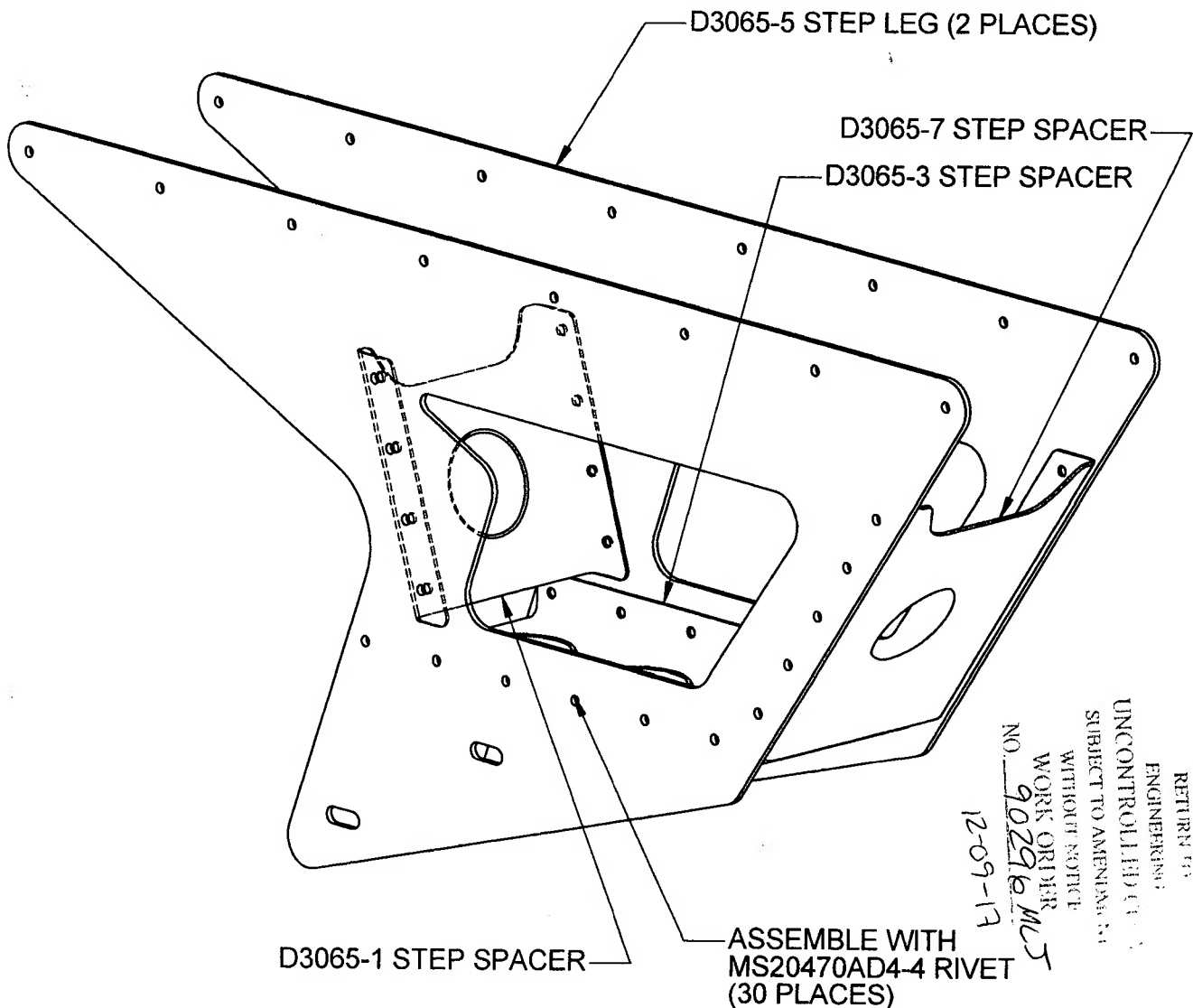
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Shop Packet Print

Page 2

DART

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CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3065	REV. B SHEET 1 OF 5
DATE 06.05.23		TITLE STEP LEG ASSEMBLY	SCALE 1:2
A	02.09.11	NEW ISSUE	
B	06.05.23	ADD 6061-T6 MATERIAL, ADD SLOTS TO D3065-5	

RELEASED*06.06.20* *[Signature]*

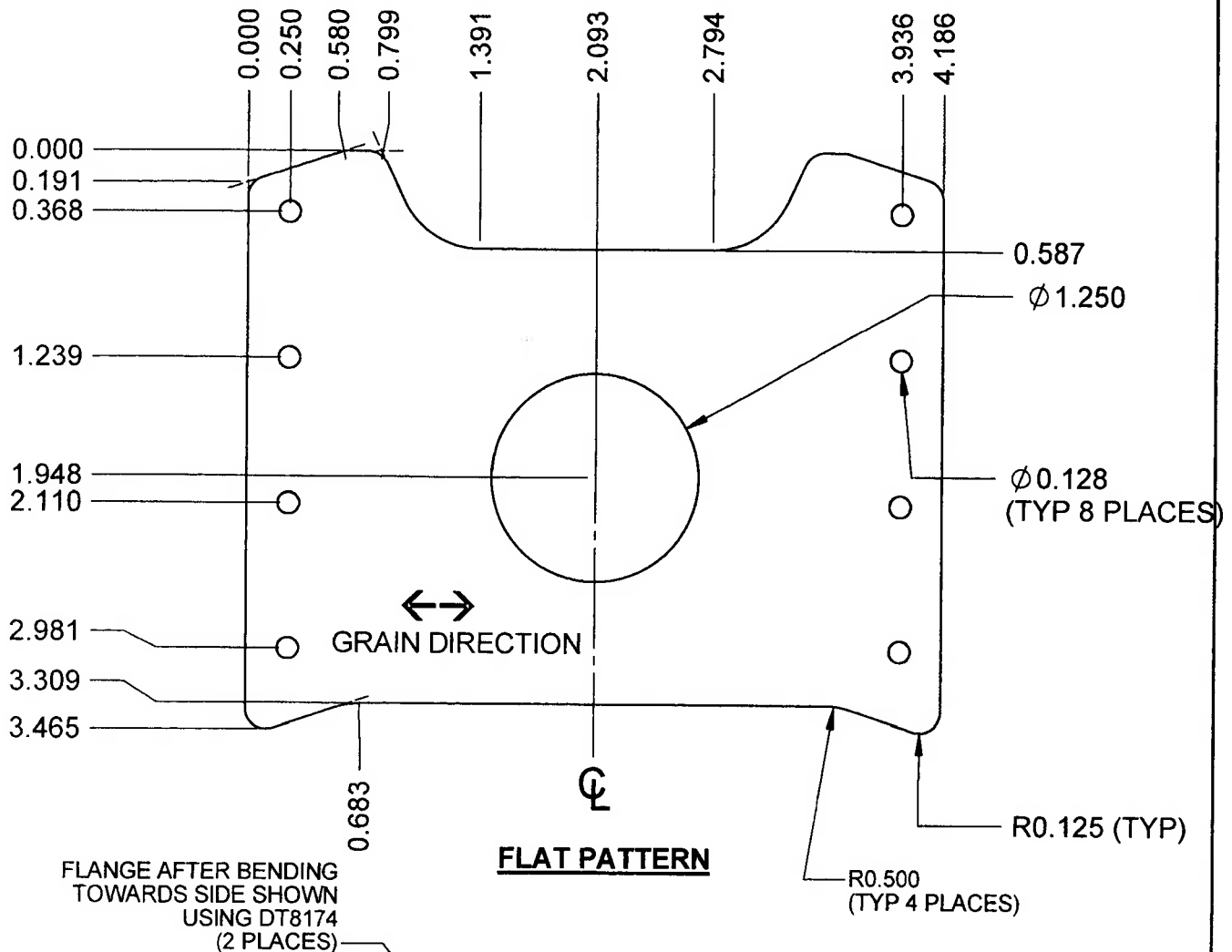
SHOP COPY
RETURN TO
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WITHOUT NOTICE
WORK ORDER
NO. *90296 M5*
12-09-17

D3065-041 STEP LEG ASSEMBLY**COPYRIGHT © 2002 BY DART AEROSPACE LTD.**

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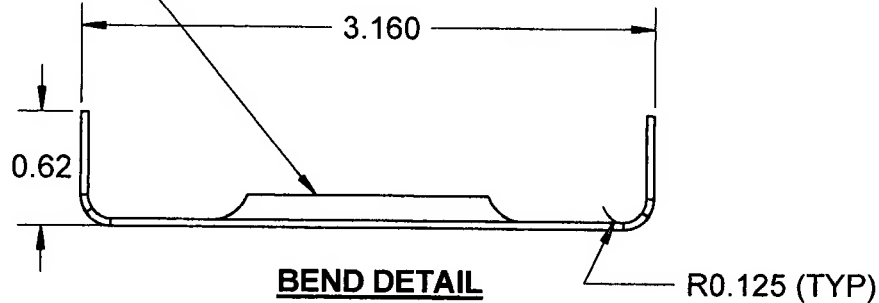


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CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3065	REV. B SHEET 2 OF 5
DATE 06.05.23	TITLE STEP LEG ASSEMBLY		SCALE 1:1



RELEASED

CP CB PH



D3065-1 STEP SPACER

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

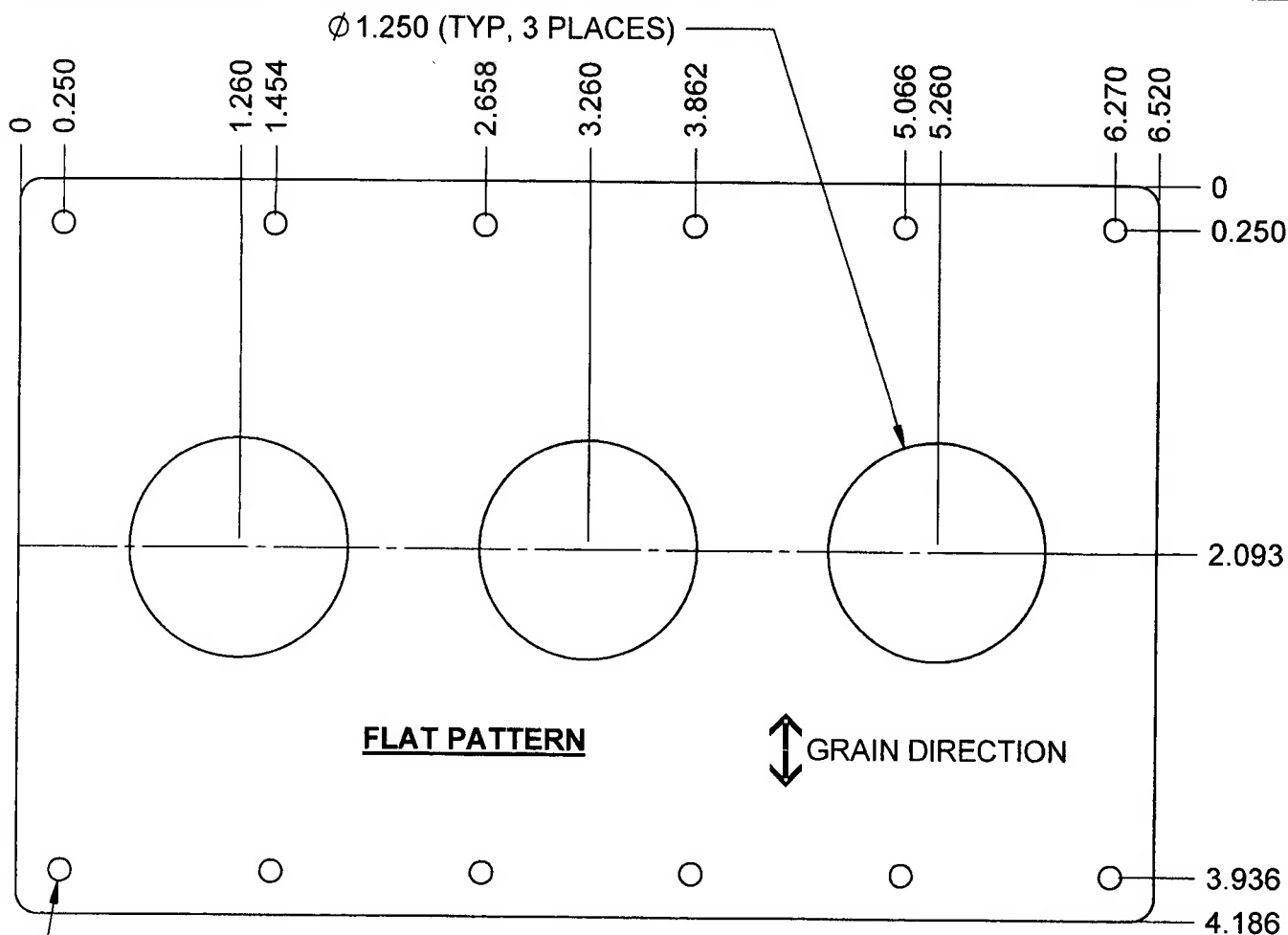
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CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3065	REV. B SHEET 3 OF 5
DATE 06.05.23	TITLE STEP LEG ASSEMBLY		SCALE 1:1

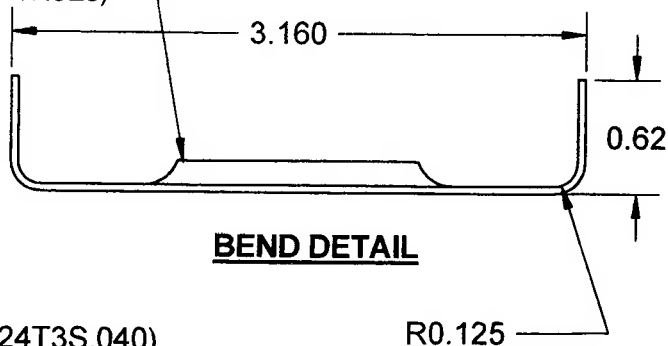


FLANGE AFTER TOWARDS SIDE
SHOWN USING DT8174 (3 PLACES)

Ø 0.129 (TYP, 12 PLACES)

RELEASED

06 Oct 20 *[Signature]*



BEND DETAIL

D3065-3 STEP SPACER

- 1) MATERIAL: 2024-T3 (QQ-A-250/4)
0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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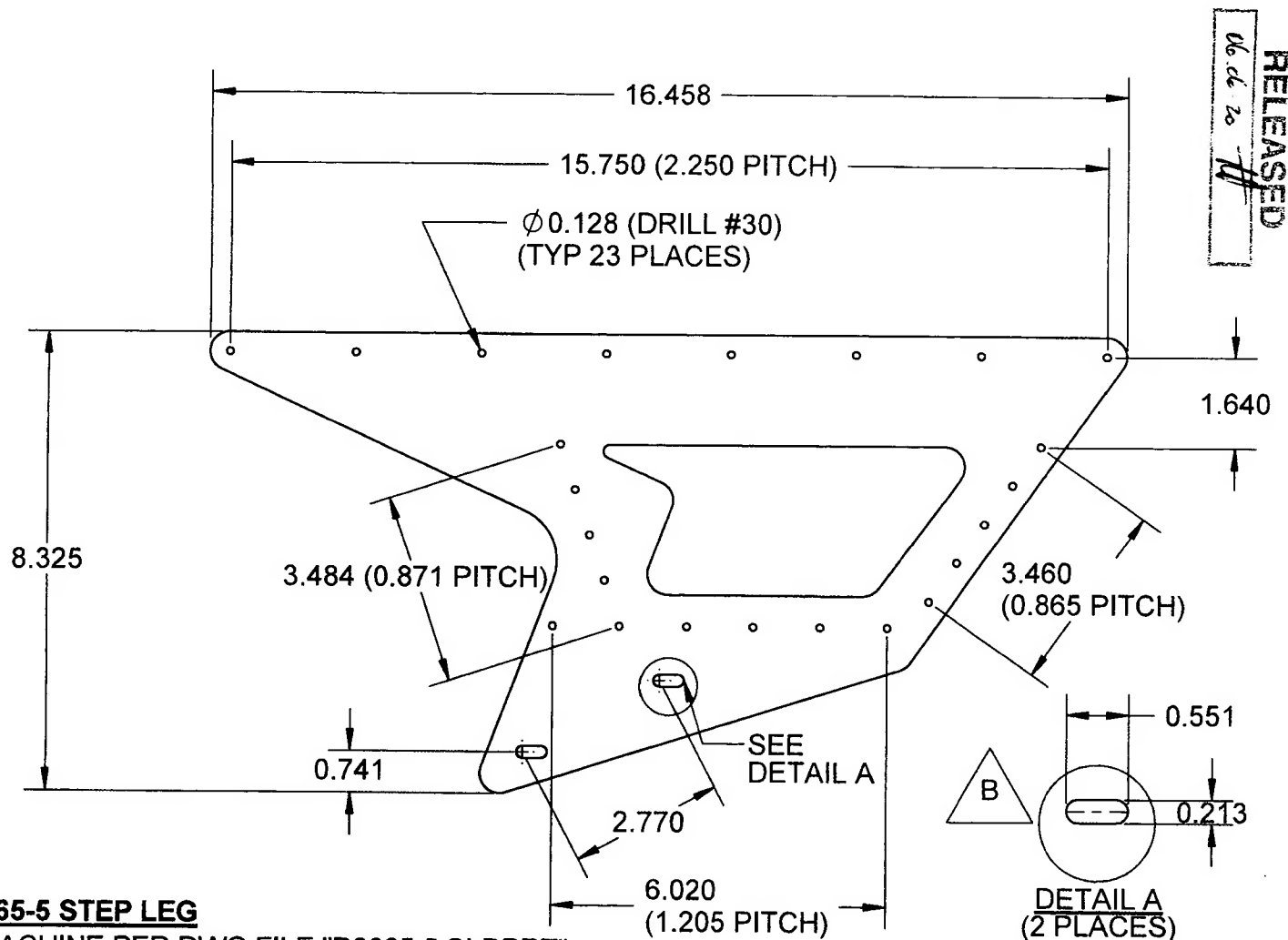
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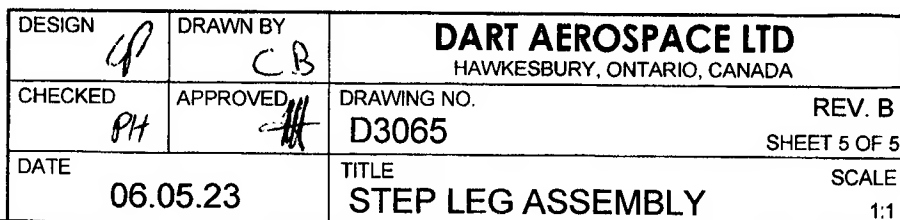
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CHECKED	PH	APPROVED		HAWKESBURY, ONTARIO, CANADA
DATE	06.05.23	DRAWING NO.	D3065	REV. B
		TITLE	STEP LEG ASSEMBLY	SHEET 4 OF 5
		SCALE	1:3	

**D3065-5 STEP LEG**

- 1) MACHINE PER DWG FILE "D3065-5.SLDPRT"
- 2) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK (REF DART SPEC M6061T6S.080)
OR
5052-H32 (PER QQ-A-250/8 OR AMS 4016) 0.080 THICK (REF DART SPEC. M5052H32S.080)
- 3) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
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- 1) MATERIAL: 2024-T3 (PER QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040)
2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
3) PART IS SYMMETRIC ABOUT CENTERLINE
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